

Date: Monday, 8/21/2006 2:10:53 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LID PRO ARM ASSEMBLY (SHORT)		
Job Number	: 28246					
Estimate Number	: 10258					
P.O. Number	: N/A		Part Number	: D2332041		
This Issue	: 8/21/2006	S.O. No. : N/A	Drawing Number	: D2332 REV C1		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: C1		
Previous Run	: 27690		Material	: N/A		
Written By			Due Date	: 9/20/2006		
Checked & Approved By			Qty:	20	Um:	Each
Comment	: Est: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/ RF					
Additional Product						
Job Number:						
Seq. #:	Machine Or Operation:	Description :				
1.0	M304TR1000W049	304 RD Tube 1.0" x .049W				
						
		Comment: Qty.: 0.4368 f(s)/Unit Total : 8.7360 f(s) Material: 1.000" OD x 0.049" wall SS Tube (Seamless) <i>M19448</i>				
		<i>-MF-</i> <i>06/08/30</i> Batch				
2.0	M304R250	1/4" 304 SS Roundbar				
						
		Comment: Qty.: 0.1092 f(s)/Unit Total : 2.1840 f(s) Material: Ø0.250" 304SS Rod <i>M17931</i>				
		<i>-MF-</i> <i>06/08/29</i>				
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1				
						
		Comment: SMALL & MEDIUM FAB RESOURCE 1				
		1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar <i>MF. 06/08/31</i>				
		2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin <i>MF. 06/08/29</i>				
		3-Deburr				
4.0	M304TR0500W035	304 RD Tube .500 x .035W				
						
		Comment: Qty.: 1.2080 f(s)/Unit Total : 24.1600 f(s) 304 RD Tube .500 x .035W				
		<i>M1W1593</i> <i>MF. 06/09/05</i>				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Seq. #: Machine Or Operation:

Description :

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012

(Note: Make (2) D2332-11 Prop Arms per assembly.)

EB 06/09/01 (20)

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly) MF. 06/09/01 (20)

2-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly)

A/R SS Rod Batch: M100372

M06/09/07 (20)

7.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

ID 06.09.07 (20)

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

MF. 06/09/08. (20)

2-Assemble as per Dwg D2332

MF. 06/09/19. (20)

9.0 AN44A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN4-4A	Bolt	m100851

MF. 06/09/19

10.0 AN960JD416L Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	AN960JD416L	Washer	m101231

MF. 06/09/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/09/20

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Part Number: D2332041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0 MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS21042L4	Nut (or -4)	m1 9085

m1 9085

mf - 06/09/19

12.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB de/09/19

20

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST/69

W
L3 06/09/20

20

14.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/09/20

20

Job Completion



U 06/09/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

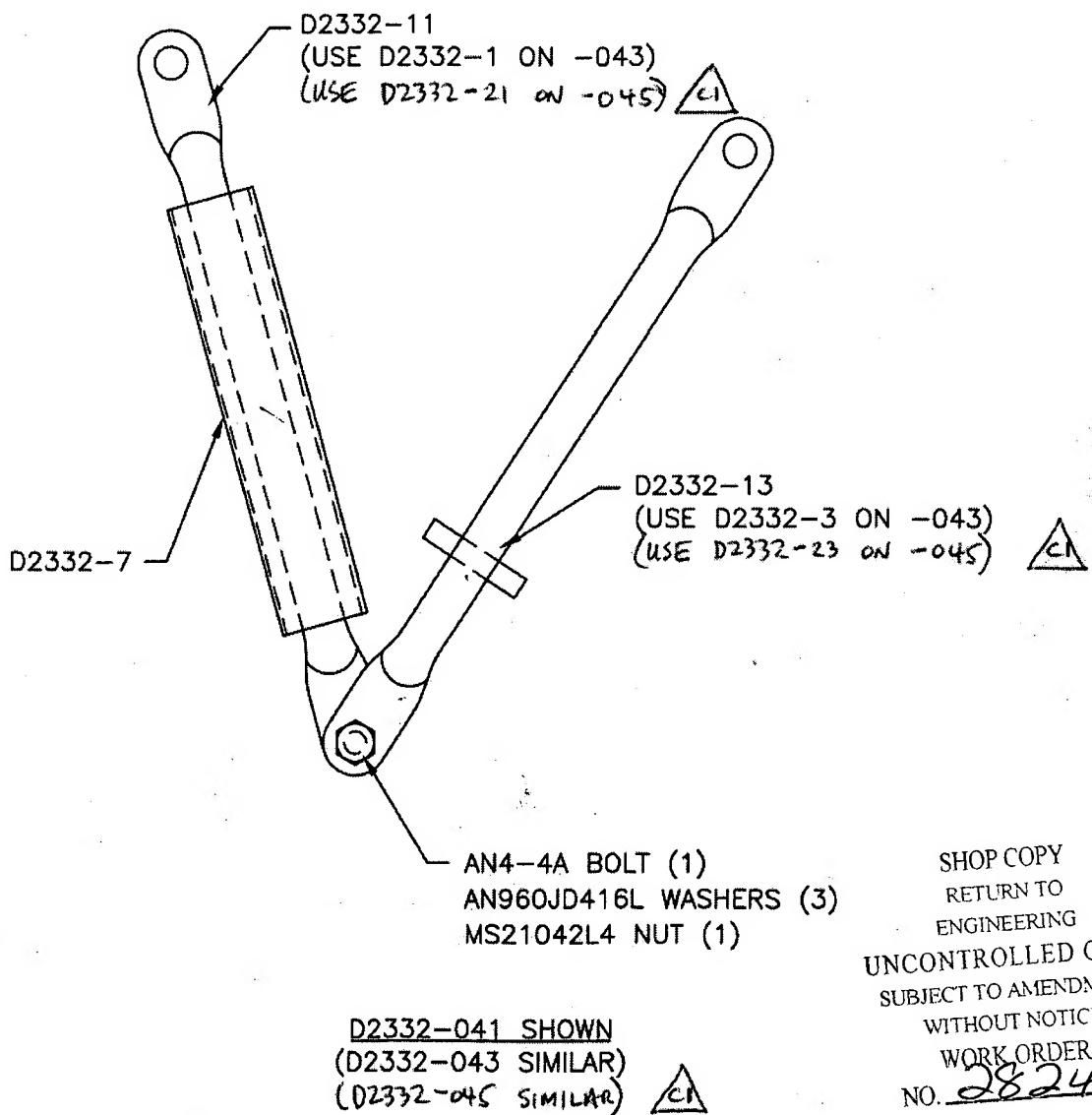
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART

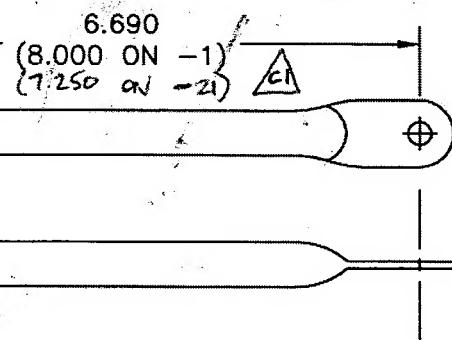
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2332	SHEET 1 OF 2
DATE		TITLE	SCALE
03.07.03		LOD PROP ASSEMBLY	NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
 03.07.04


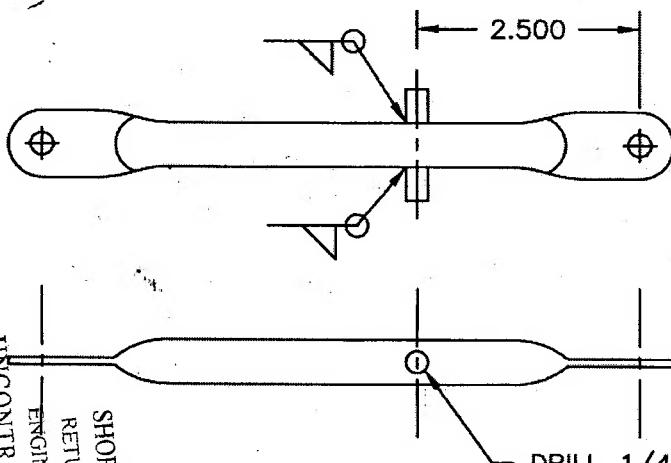
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RELEASED
03.07.04

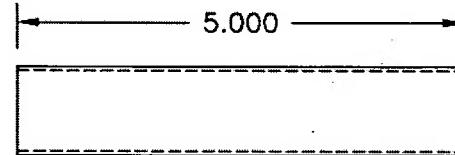


D2332-11 PROP
(D2332-1 SIMILAR)

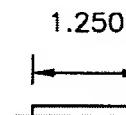


D2332-13
M/F D2332-11 & D2332-5

D2332-3 SIMILAR - M/F D2332-1 & D2332-5
D2332-23 SIMILAR - M/F D2332-21 & D2332-5



D2332-7 LOCKING COLLAR



D2332-5 STOP PIN

DART

©ACOPY
Gens

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. C

DESIGN	DRAWN BY	DART AEROSPACE LTD
		HAWKESBURY, ONTARIO, CANADA
DATE	CHECKED	DRAWING NO.
03.07.03	<input checked="" type="checkbox"/>	D2332
C	<input checked="" type="checkbox"/>	MALE -041 PROP 6.69" LONG (4in) M/F 8.00" LONG (6in)
C1	<input checked="" type="checkbox"/>	ADD -045 PROP (7.25" LONG)

SCALE
1:12

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26246

NOTES:

1. MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
2. TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13